MACHINE : **PUMA VT900-2SP**
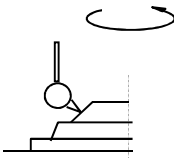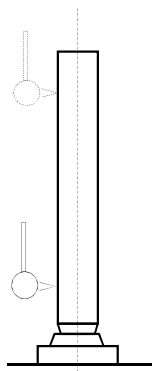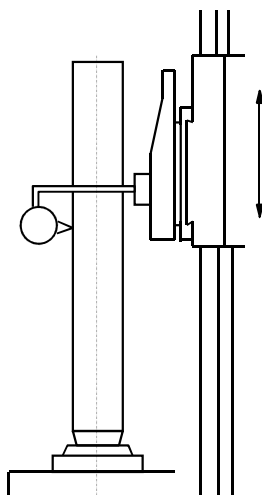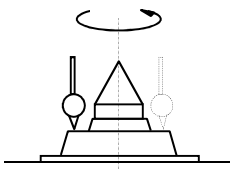
SERIAL NO : **MT0030-000000**

DATE : **Oct. 14. 2013**
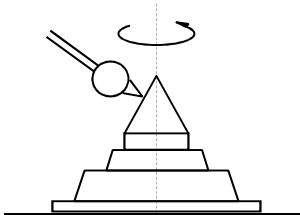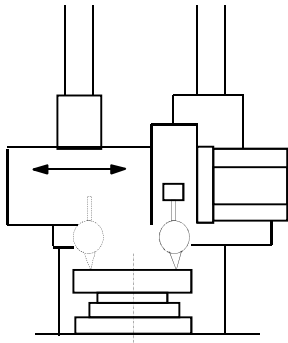
TURNING CENTER
TEST RECORD

DOOSAN

CHANGWON KOREA

NC LATHE TEST RECORD

SIZE	1000 X 850	MACHINE NO.	MT0030-000000

1. GEOMETRICAL TEST

UNIT : mm (inch)

No.	ITEM		ILLUSTRATION	PERMISSIBLE ERROR SWING		READING
				UP TO 1000	UP TO 2000	
1	SPINDLE NOSE RUNOUT			0.02	0.02	LEFT
						RIGHT
2	SPINDLE HOLE RUNOUT			0.02 (0.0008)	0.03 (0.0012)	LEFT
						RIGHT
				AT THE END OF SPINDLE NOSE		
				0.03	0.04	LEFT
						RIGHT
				AT THE END OF 300 TEST BAR		
3	PARALLELISM OF SPINDLE WITH CARRIAGE MOVEMENT	A. IN VERTICAL PLANE		0.02	0.03	LEFT
						RIGHT
		B. IN HORIZON-TAL PLANE		0.02	0.02	LEFT
						RIGHT
4	CAM ACTION OF SPINDLE FLANGE			0.02 (0.0008)	0.02 (0.0008)	LEFT
						RIGHT

GEOMETRICAL TEST

No.	ITEM	ILLUSTRATION	PERMISSIBLE ERROR		READING	
			SWING			
			UP TO 1000	UP TO 2000		
5	SPINDLE CENTER RUNOUT		0.02 (0.0008)	0.03 (0.0012)	LEFT	
					RIGHT	
6	SQUARENESS OF CROSS SLIDE MOVEMENT WITH SPINDLE		0.03 IN 300(12") TO CONCAVE FACE ONLY	0.04	LEFT	
					RIGHT	

UNIT : mm (inch)

DATE :

INSPECTED BY :

APPROVED BY :

DOOSAN
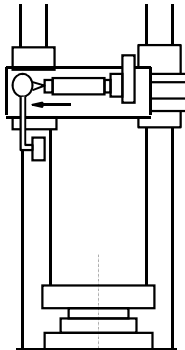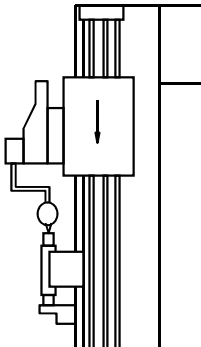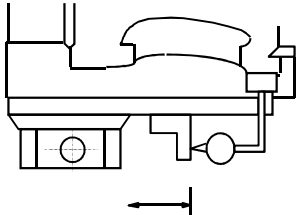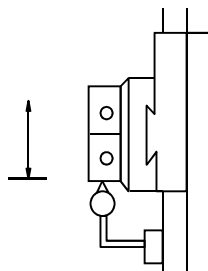
1. POSIOTIONING ACCURACY FOR EACH LENGTH

UNIT : mm (inch)

NO.	AXIS	ILLUSTRATION	PERMISSIBLE ERROR		READING
			SWING		
			UP TO 1000	UP TO 2000	
1	X - AXIS		0.01 (0.0004)	0.01 (0.0004)	LEFT SIDE
					L
					R
			IN 100(4")		RIGHT SIDE
					L
					R
2	Z - AXIS		0.02 (0.0008)	0.025 (0.0010)	HEAD STOCK SIDE
					L
					R
			IN 300(12")		COUNTER SIDE
					L
					R
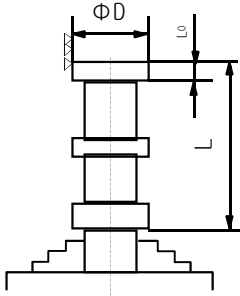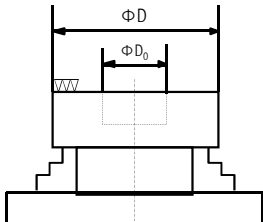
2. REPEATABLE ACCURACY FOR POSITIONING

NO.	AXIS	ILLUSTRATION	SWING UP TO 1000	UP TO 2000	READING
1	X - AXIS		±0.002 (0.00007)	±0.003 (0.0001)	1/2 OF MAX.DIFFERENCE (BY 7 MEARSUREMENT) L : R :
2	Z - AXIS		±0.003 (0.0001)	±0.005 (0.0002)	1/2 OF MAX.DIFFERENCE (BY 7 MEARSUREMENT) L : R :

3. PRACTICAL TEST

NO.	ITEM	ILLUSTRATION	APPROX. DIMENSION OF WORKPIECE			PERMISSIBLE ERROR		READING (mm)
			SWING	D	L	ROUND-NESS	CYLINDRI-CAL SHAPE	
1	ACCURACY OF BAR CUTTING		500(20") TO 750(30") INCL.	120 (4.8")	225 (9")	0.012 (0.00048)	0.018 (0.00072)	**RIGHT** [ ] CYLINDRICAL [ ]
			750(30") TO 1,000 (40") INCL.	160 (6.3")	300 (12")	0.014 (0.00055)	0.020 (0.0008)	**LEFT** [ ]
			1,000 (40") TO 1,500 (60") INCL.	240 (9.4")	450 (18")	0.016 (0.00063)	0.023 (0.0009)	CYLINDRICAL [ ]
2	ACCURACY OF FACE CUTTING		SWING	D	FLATNESS		READING	
			500(20") TO 750(30") INCL.	300 (12")	0.02 (0.0008) PER DIA.		**RIGHT** [ ] (CONCAVE)	
			750(20") TO 1,000 (40") INCL.	400 (16")	0.02 (0.0008) PER DIA.		**LEFT** [ ] (CONCAVE)	
			1,000 (40") TO 1,500 (60") INCL.	500 (20")	0.03 (0.0012) PER DIA.			

DOOSAN

( )inch